

ASAP 23/01

Dart Aerospace Ltd.

Date: Friday, 16/01/2009 12:33:44 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SLIDING DOOR BRACKET
<b>Job Number</b> : 44875	
<b>Estimate Number</b> : 13643	
<b>P.O. Number</b> :	<b>Part Number</b> : D36753
<b>This Issue</b> : 16/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3675 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 43441	<b>Material</b> :
<b>Written By</b> : <u>                    </u>	<b>Due Date</b> : 23/01/2009 <b>Qty:</b> 30 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>                    </u>	
<b>Comment</b> : Est Rev:A new issue 08-11.06 EC verified by:DD	

## Additional Product

Job Number:



SCRAP

Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.1271 sf(s)/Unit Total : 3.8115 sf(s)  
 304 stainless steel 0.032" Sheet  
 Batch: 108057 IB 9-1-18

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3675  
 Dwg Rev: B  
 Prog Rev: B

IB 9-1-18

(33)

2-Deburr if necessary IB 9-1-18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-1-18

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 02/01/19 counter (33)

5.0	BRAKE NC	NC BRAKE
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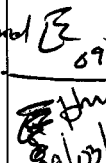
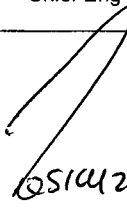
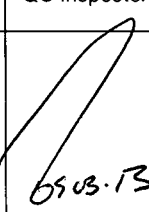


**Comment:** NC BRAKE  
 Form as per Dwg D3675

SB 09/01/20 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3675-3 PAR #: N/A Fault Category: Prod Eng. Coordinator NCR: (Yes) No DQA: D Date: 09/03/20  
 Resolution: Documentation revised Disposition: Scrap QA: N/C Closed: D Date: 09/03/20

NCR: <u>44875</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-13	2.0	Parts were made with 0.032" material instead of 0.040"; and measure 0.028" → 0.030" R.C: Incorrect mat'l size on I.O.	 QS/ur2	update I.P.P. seq. 1.0 to state 0.040" material instead of 0.032" Scrap & destroy Qty 33 no replace.	 89/03/18	09/03-13 SB 09/03/18	 QS/ur2	 09-03-13

NOTE: Date & initial all entries

Date: Friday, 16/01/2009 12:33:44 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 44875

Part Number: D36753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/21 (x33) counters

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

M1109648

SCRAP

09-01-23

(x33)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

88 PPP 42198

SS

09/01/23 (x33)

(PTO)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-03-18

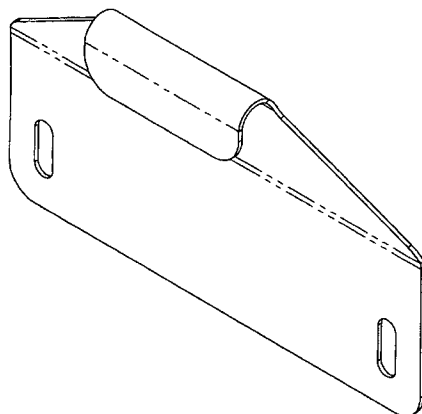
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

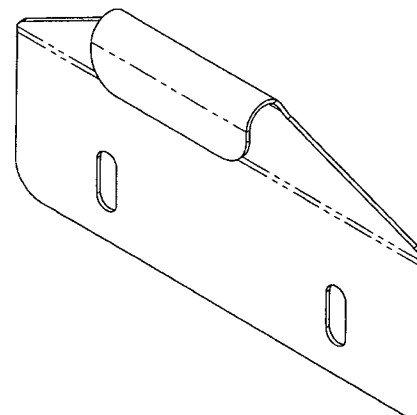
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3675-1 SLIDING DOOR BRACKET**



**D3675-3 SLIDING DOOR BRACKET  
(HINGE PANEL MOD)**

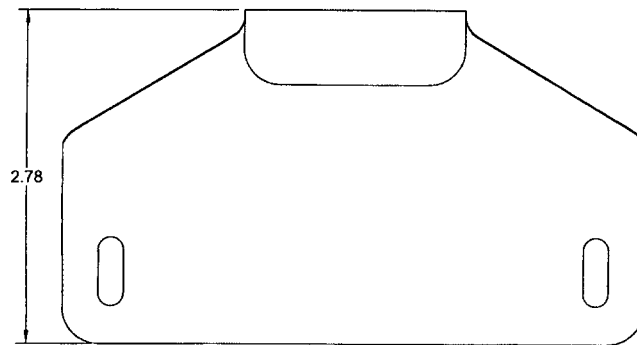
*W/O 44875*

**RELEASED**  
08.11.10

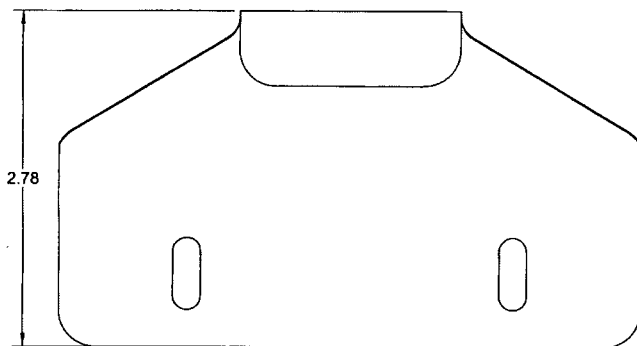
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED)  
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

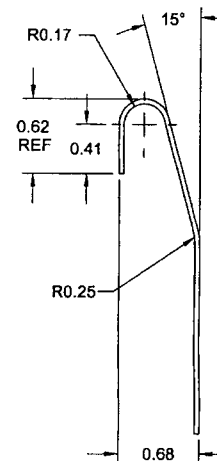
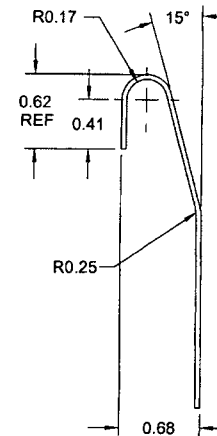
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 1 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



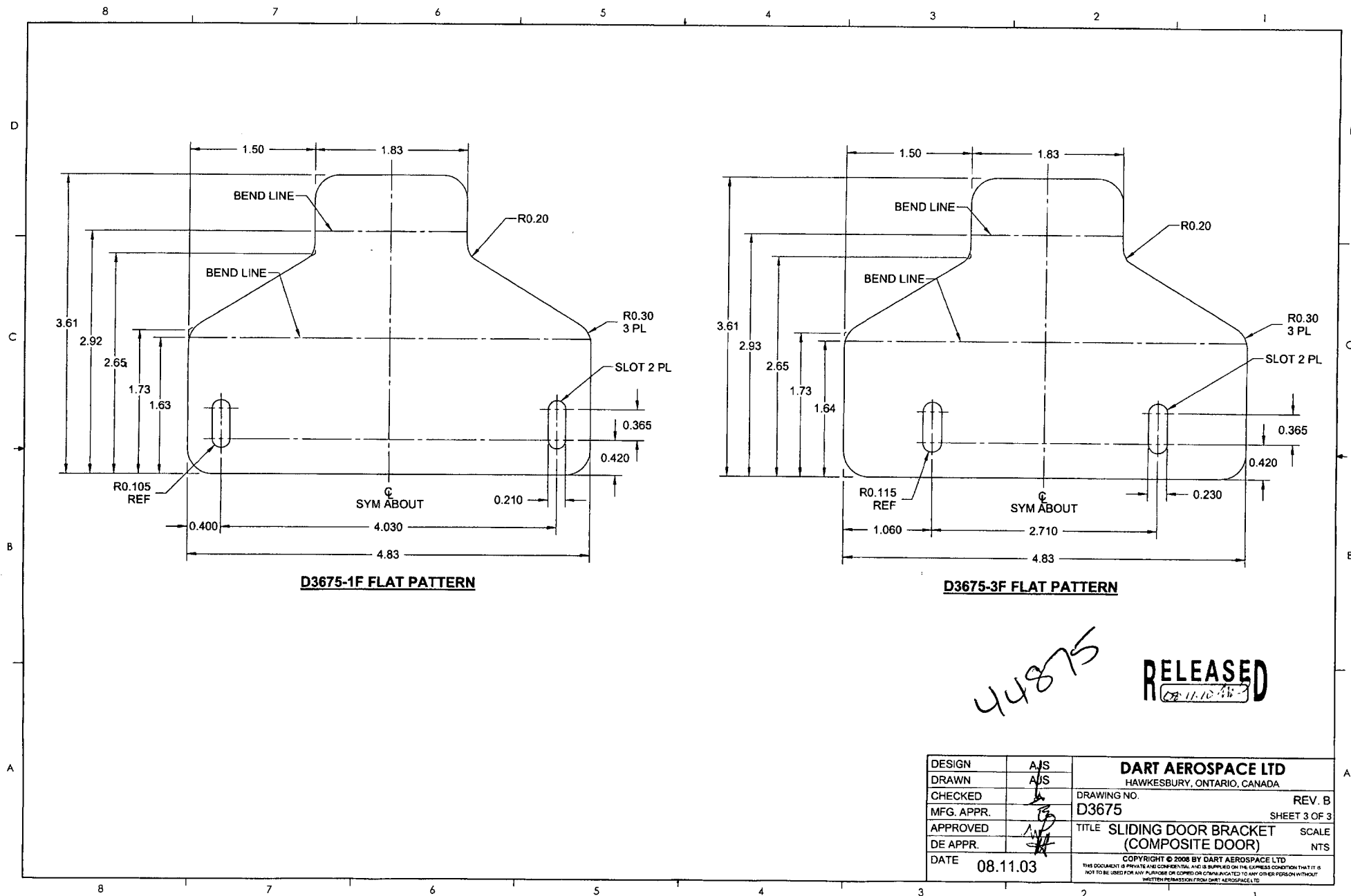
**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)



44875

RELEASED  
08.11.03

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS
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44875

RELEASED  
08.11.03

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3675</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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**L Lacelle**

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**From:** L Lacelle [llacelle@dartaero.com]  
**Sent:** January 23, 2009 3:25 PM  
**To:** 'Bill Beckett'  
**Cc:** 'Brigitte Golden'; 'sbedford@dartaero.com'; 'Jason Murdoch'  
**Subject:** AMOD OE 6482

Well, since this order (for this last item) has been a disaster since it started last Friday, it decided to continue. Now, I had the D3202-5's made, painted and ready to add into the kits so it could ship Monday morning, but it will NOT be leaving Monday...the comment on the w/o (estimate too) D3675-3, was wrong, so parts were made to .032 mat'l instead of .040 for the first batch (the second batch was caught on inspection). I was closing the sub component w/o's for this part D3675-3 when I noticed it, and informed Jason. So....we will have to make a 3<sup>rd</sup> batch of these on Monday, and if we can get thru another miracle of pulling parts out of my ass, we will have them ready to ship Tuesday morning.  
Have a great wknd

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

13/03/2009